

Date: Monday, 10/11/2008 10:42:48 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RH STEP ACTUATOR ASSEMBLY
Job Number : 43268	
Estimate Number : 12760	
P.O. Number :	
This Issue : 10/11/2008 S.O. No. :	Part Number : 41232 000 001 002
Prsht Rev. : NC	Drawing Number : 41232-000-001 REV A
First Issue : // Type : SMALL /MED FAB	Project Number : N/A
Previous Run : 43222	Drawing Revision : A
Written By :	Material :
Checked & Approved By : JUD 08/11/08	Due Date : 01/12/2008 Qty: 2 Um: Each
Comment : Est Rev:A New Issue 07-02-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Handwritten: JUD 08/12/02



Comment: DOCUMENT CONTROL

Photocopy bluefile D412-763 & type labels per PPP41232-000-001 CHG 002

Handwritten: 08/12/02

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	AP0925ELBN	BARBED ELBOW
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

BARBED ELBOW

Batch:

Handwritten: M103727

Handwritten: SS 08/12/02

4.0	AN960JD416	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Batch:

Handwritten: M109249

Handwritten: SS 08/12/02

5.0	MS21042L4	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch:

Handwritten: M108145

Handwritten: SS 08/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/11/2008 10:42:48 AM
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Part Number: 41232 000 001 002

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 AN423A ✓ Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch:

107378

SS 08/12/02 (X2)

7.0 MS3548993 ✓ GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

GROMMET

Batch:

M106168

SS 08/12/02 (X2)

8.0 AN960JD416L ✓ Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

M109388

SS 08/12/02 (X2)

9.0 MS24665151 ✓ Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Cotter Pin

M14526

SS 08/12/02 (X2)

10.0 MS203923C21 ✓ Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pin

M104156

SS 08/12/02 (X2)

11.0 R 3400 ✓ plastic tubing 1/4id x 3/8od-black



Comment: Qty.: 3.0500 f(s)/Unit Total: 6.1000 f(s)

plastic tubing 1/4id x 3/8od-black

Cut to 18" Long X2 measured

Batch:

M109886

SS 08/12/02 (X2)

12.0 41232 200 006 001 ✓ Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bracket

Batch:

30505

SS 08/12/02 (X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 43268

Part Number: 41232 000 001 002

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	41232 200 005 001	Spacer (Step Actuator)
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)
Spacer (Step Actuator)
Batch: 43253

14.0	41232 200 004 001	Reducer Tee Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Reducer Tee Assembly
Batch: 31779

15.0	41232 200 003 001	Spring (Step Actuator)
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Spring (Step Actuator)
Batch: 30941

16.0	41232 200 001 002	Step Actuator RH Ass'y
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Step Actuator RH
Batch: 43257

17.0	124K002 4CR 0545	Hose ass'y-Step Actuator
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Hose ass'y-Step Actuator
BATCH: 104042

18.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

19.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP 41232-000-001-001

Location:

PPP Rev:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 43268

Part Number: 41232 000 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/04 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.02.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

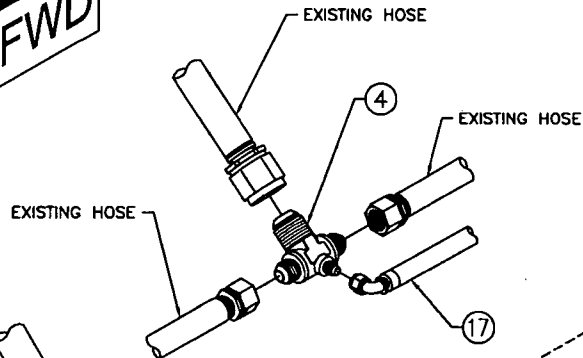
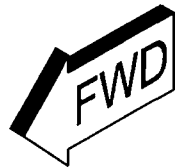
NOTE: Date & initial all entries

REVISION					
LETTER	DEFSMAN	DATE	DESCRIPTION	APPROVED	DATE
A	DNN	1/14/04	INCRP. E.O.; CHG. P/N OF ITEM #17. MINOR CHANGE - FAR 21.95	1/14/04	1/14/04

A				1	1	17	PS4025E000DF540A	HOSE					
				1	1	16	AP0925ELBN	BARBED ELBOW	ARK-PLAS PRODUCTS, INC., FLIPPIN, ARKANSAS 72634				
				2	2	15	AN960JD416	WASHER					
				1	1	14	MS21042-L4	NUT					
				1	1	13	AN4-23A	BOLT					
				AR	AR	12	MIL-S-8802	SEALANT					
				1	1	11	MS35489-93	GROMMET					
				2	2	10	AN960JD416L	WASHER					
				1	1	9	MS24665-151	COTTER PIN					
				1	1	8	MS20392-3C21	PIN					
				2	2	7	R-3400 1/4 ID x 3/8 OD BLACK	PLASTIC TUBING	NORTON PERFORMANCE PLASTICS CORP., AKRON, OHIO 44309				
				1	1	6	41232-200-006-001	BRACKET	(ALT. P/N 412-050-026-101, BELL HELICOPTER)				
				3	3	5	41232-200-005-001	SPACER					
				1	1	4	41232-200-004-001	REDUCER TEE					
				1	1	3	41232-200-003-001	SPRING					
				1		2	41232-200-001-002	R/H ACTUATOR ASSY					
					1	1	41232-200-001-001	L/H ACTUATOR ASSY.					
							-002	R/H INSTALLATION					
							-001	L/H INSTALLATION					
				-002	-001	FND NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE	

NO. REQ'D PER ASSY				LIST OF MATERIAL									
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						CHECK		D. MURPHY		5/20/02			
						STRESS							
						FUEL ENGR.							
						HEAT TREAT							
FINISH													
41232-1000				NEXT ASSEMBLY						DWA. SIZE C		SCALE NONE	
												DWA. NO. 41232-000-001	
												SHT 1 OF 2	
												REV. A	

SHOP COPY
 RETURN TO
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 WITHOUT NOTICE
 WORK ORDER
 NO. 41232-1000



L/H STEP

L/H SKID TUBE

16 INSTALL ELBOW IN EXISTING SKID TUBE HOLE PREVIOUSLY USED FOR ELECTRICAL WIRE.

11

12

412-050-017-133 COVER (REF.)

17 EXISTING FLOAT BAG

ROUTE HOSE THROUGH FLOAT BAG ATTACHMENT ALONG SIDE OF EXISTING HOSE.

EXISTING HOSE

RETAINER (REF.)

17

SCREW (REF.)

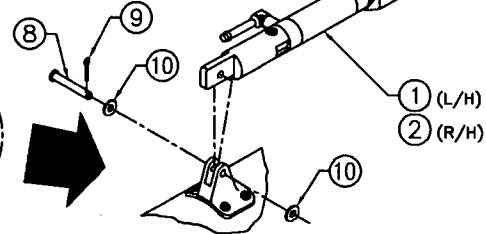
TORQUE SCREWS TO 12-15 INCH LBS.

6

BRACKET MUST BE INSTALLED AS SHOWN



VIEW LOOKING INBOARD



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Era Aviation, Inc.

STEP ACTUATOR INSTALLATION

SIZE C

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SHT 2 OF 2

REV. A

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